

Date: Tuesday, 23/09/2008 10:22:27 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET
Job Number	42231		Part Number	D33047
Estimate Number	11110		Drawing Number	D3304 REV B
P.O. Number			Project Number	N/A
This Issue	23/09/2008	S.O. No. :	Drawing Revision	B
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : SMALL /MED FAB	Due Date	20/10/2008
Previous Run	:		Qty:	12
Written By	:		Um:	Each
Checked & Approved By	<u>JUL 08 9.23</u>			
Comment	Est A 04.09.07 New issue KJ/JLM Est B 08.08.06 waterjet EC verified by DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
	Comment: Qty.: 0 sf(s)/Unit Total : 1 sf(s)	
	304/316 .040 Sheet	
	batch: 109088 HB 8-10-22	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	
	1-Cut as per Dwg D3304	
	Dwg Rev: <u>B</u>	
	Prog Rev: <u>B</u> HB 8-10-22	
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-10-22
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		S 08/10/22 (HB)
	Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE	
	1-Deburr	
	2-Form as per Dwg D3304	
	3-Tumble <u>N/A</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42231

Part Number: D33047

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



SO 8/10/23 13

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Padu/24 13

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/24 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

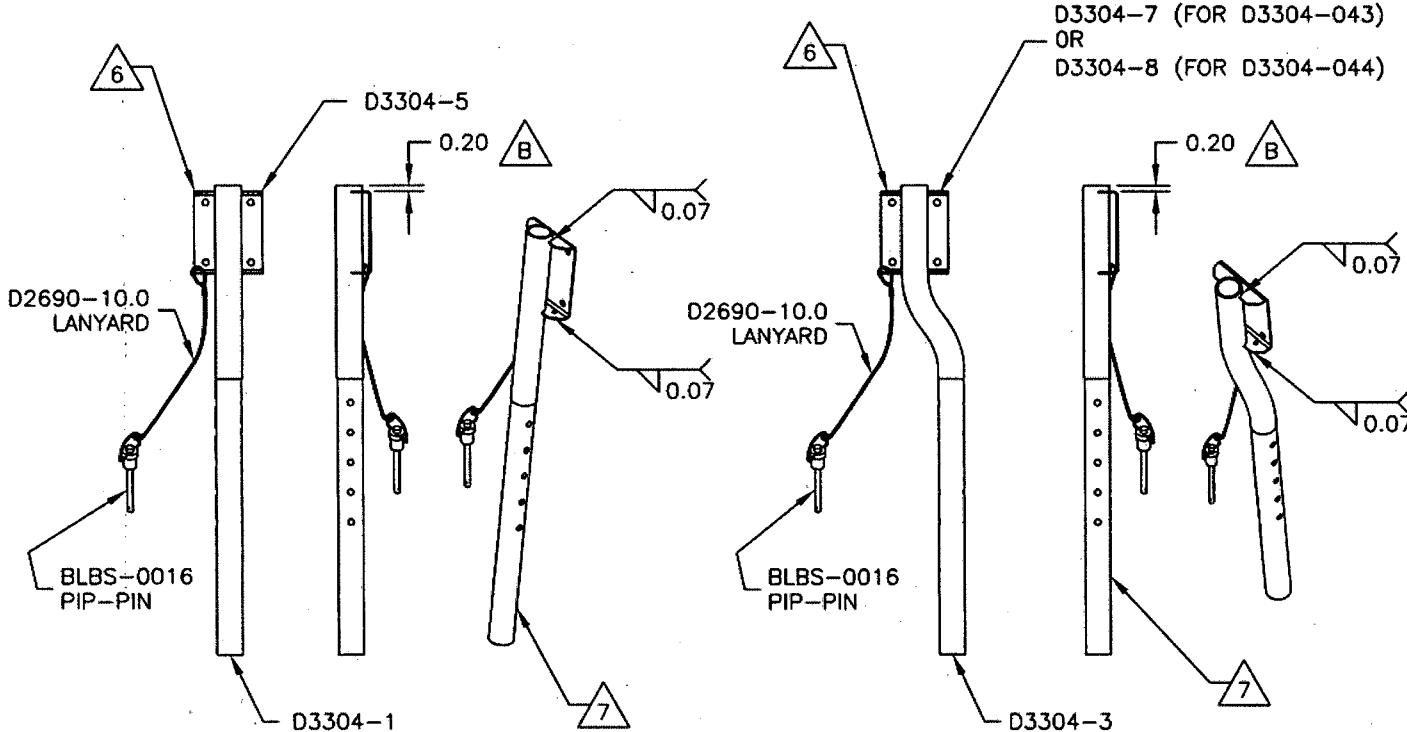
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD
CHECKED <i>H</i>	APPROVED <i>H</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.07.15	DRAWING NO. D3304	REV. B
TITLE TUBE ASSEMBLY	SCALE 1:6	SHEET 1 OF 4
A 04.08.18	NEW ISSUE	
B 05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8	



D3304-041 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE

RELEASED
5.8.15
H

D3304-041/-043/-044 NOTES:

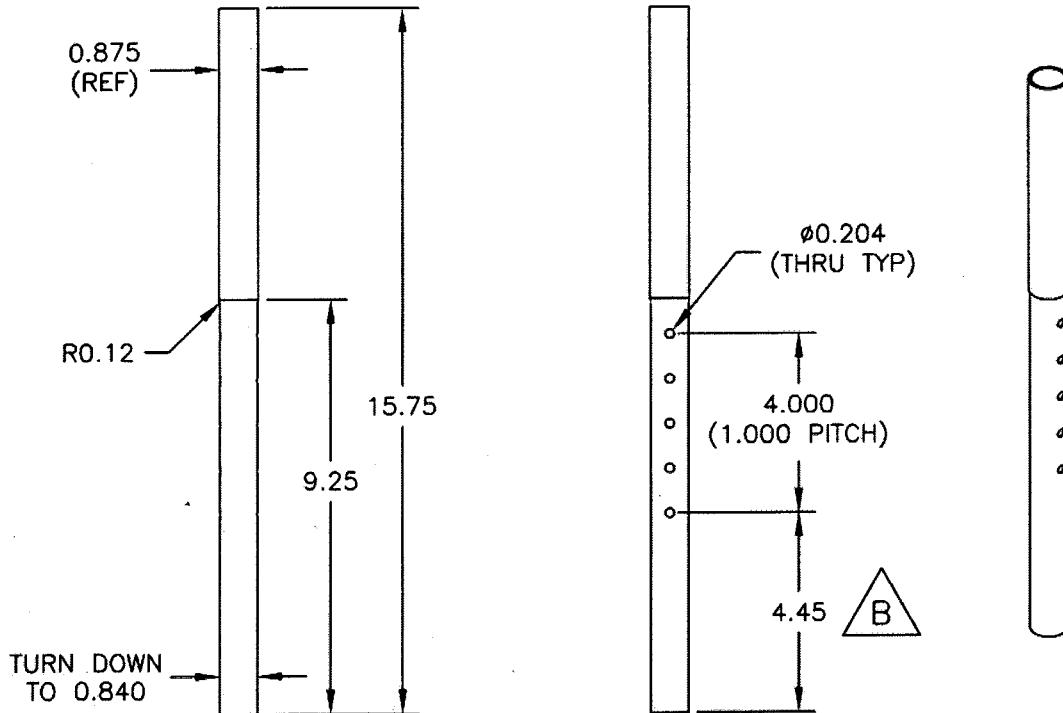
- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

UNCONTROLLED COPY
DO NOT RETURN TO
ENGINEERING
WITHOUT NOTICE
WORK ORDER
NO 42231



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3304
DATE 05.07.15	TITLE TUBE ASSEMBLY	REV. B SHEET 2 OF 4 SCALE 1:4

RELEASED
05.08.11 *[initials]*



D3304-1 TUBE

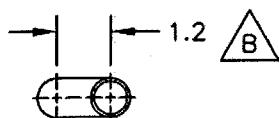
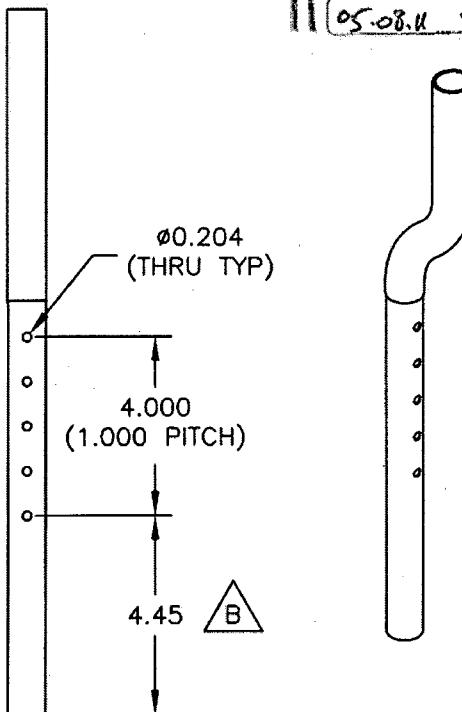
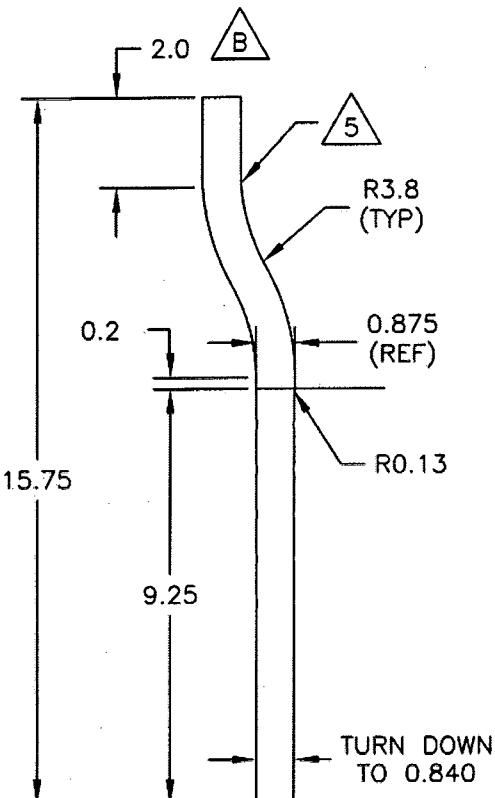
D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER
NO. *4223*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

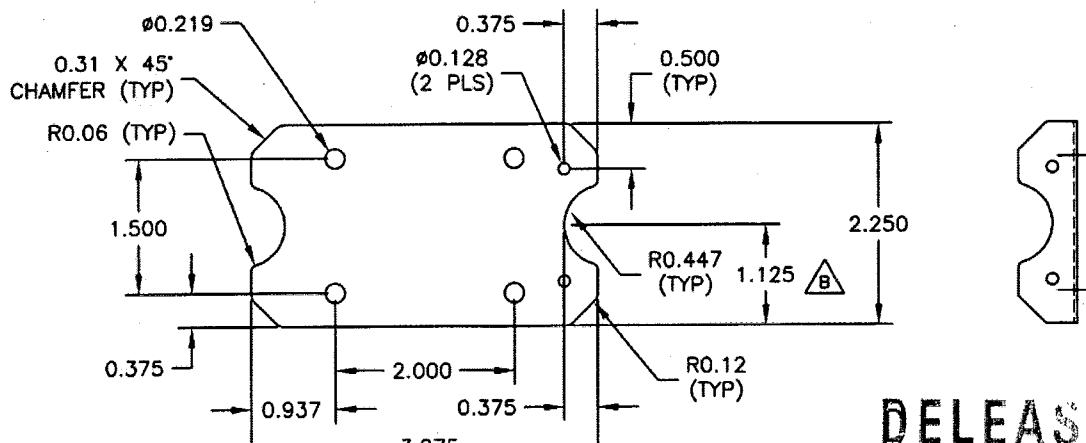
**D3304-3 TUBE****D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

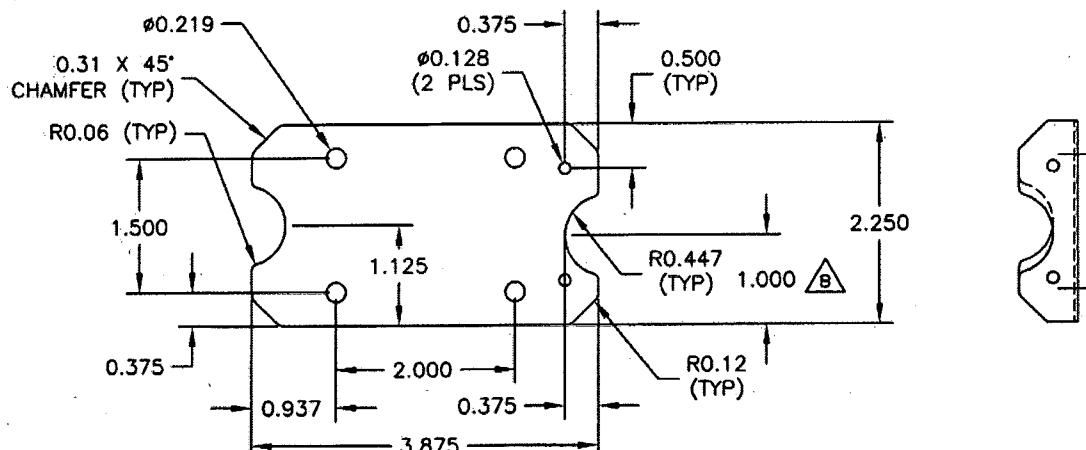
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WORK ORDER
NO. *42231*



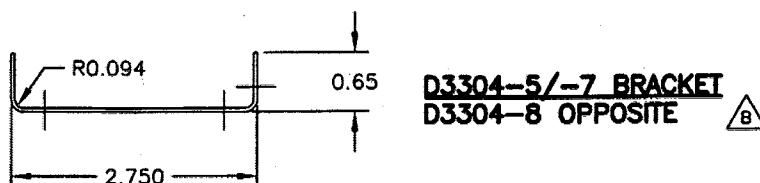
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:2



D3304-5 FLAT PATTERN



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WITHOUT NOTICE
WORK ORDER
NO. 42201

DART AEROSPACE LTD	Work Order:	42231
Description: BRACKET	Part Number:	D3304-1
Inspection Dwg: D3304-1, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: HB	Audited by: S	Prototype Approval: 1
Date: 8-10-21	Date: 08/10/21	Date: 4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	